

Date: Monday, 22/09/2008 2:00:22 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET ASSEMBLY
 Job Number : 42189
 Estimate Number : 10278
 P.O. Number :
 This Issue : 22/09/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D3121141
 Drawing Number : D3121 REV E
 Project Number : N/A
 First Issue : / / Type : MACHINED PARTS Drawing Revision : E
 Previous Run : 40250 Material :
 Due Date : 25/10/2008 Qty: 140 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev: Pick: A 04.02.18 New issue KJ/DS
 Est Rev: B ECN 1060 07-11-12 DD verified by: EC
 Est Rev: C New Dimensions for Blank Size 08-07-23 JLM Verified
 By: EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M174B1250X02000 17-4 SS Bar 1.250 x 2.00



(84)

Comment: Qty.: 0.5775 f(s)/Unit Total: 80.8500 f(s)

Material: 17-4 SS Bar per AMS 5604/5643

(M17-4-B1.250x02.000)

Identify for D3121-111

Batch: M108855

M109457X(84) 56 - 32.34

MME 08/09/24

2.0 BAND SAW BAND SAW



(84)

Comment: BAND SAW

Cut blanks: (1.000" x 2.000") 6.600" long

MME 08/09/24

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D3121-111 as per Folio FA301 and Dwg D3121 Identify as D3121-111

2-Deburr

3-Scribe batch number

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Receive + Inspect for transit damage
 Ensure C of C attached

P=8/24/15 (134)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 22/09/2008 2:00:22 PM
User: Linda Lacelle

Process Sheet

(12)

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 42189

Part Number: D3121141

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

SECOND CHECK



counters

Comment: SECOND CHECK

Inspect level 5

08/11/20

(4139)

6.0

D312121

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 140.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3121-21

Bolt

B40351

(51X)

~~B42201~~

B42201

(88X)

08/11/21

7.0

D3121241

Bearing Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 140.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3121-241 Bearing Ass

B39948

(17X)

B42177

(22)

08/11/21

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3121-141 as per Dwg D3121.

scribble Batch number

08/11/24

(139)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/11/24

counters

(4139)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

57233

08/11/28 (139)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/26

MF

Job Completion



MF 08-11-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

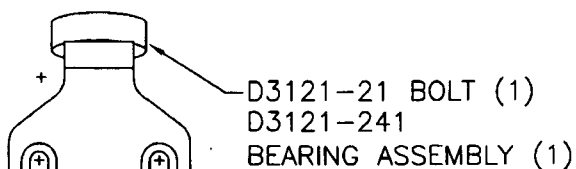
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



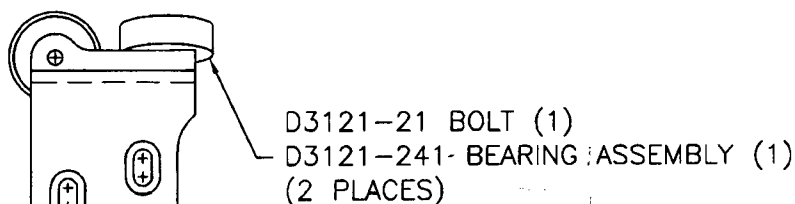
DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 2 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2



D3121-111 BRACKET

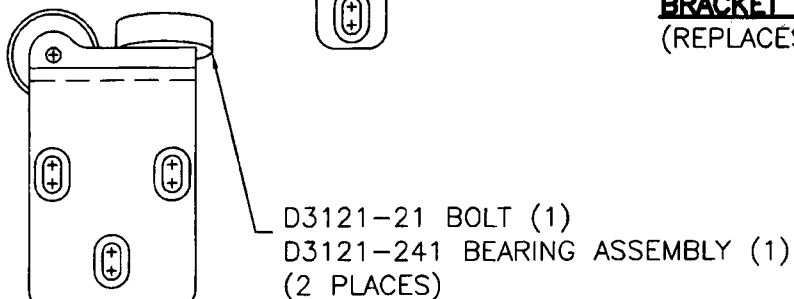
D3121-141 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23001-01)

RELEASED
07.11.07



D3121-113/-114 BRACKET

D3121-143 (SHOWN) / D3121-144 (OPPOSITE)
BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-03/-04)



D3121-115/-116
BRACKET

D3121-145 (SHOWN) / D3121-146 (OPPOSITE)
BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-05/-06)

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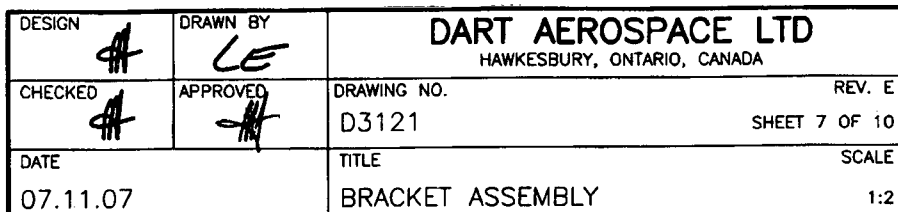
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

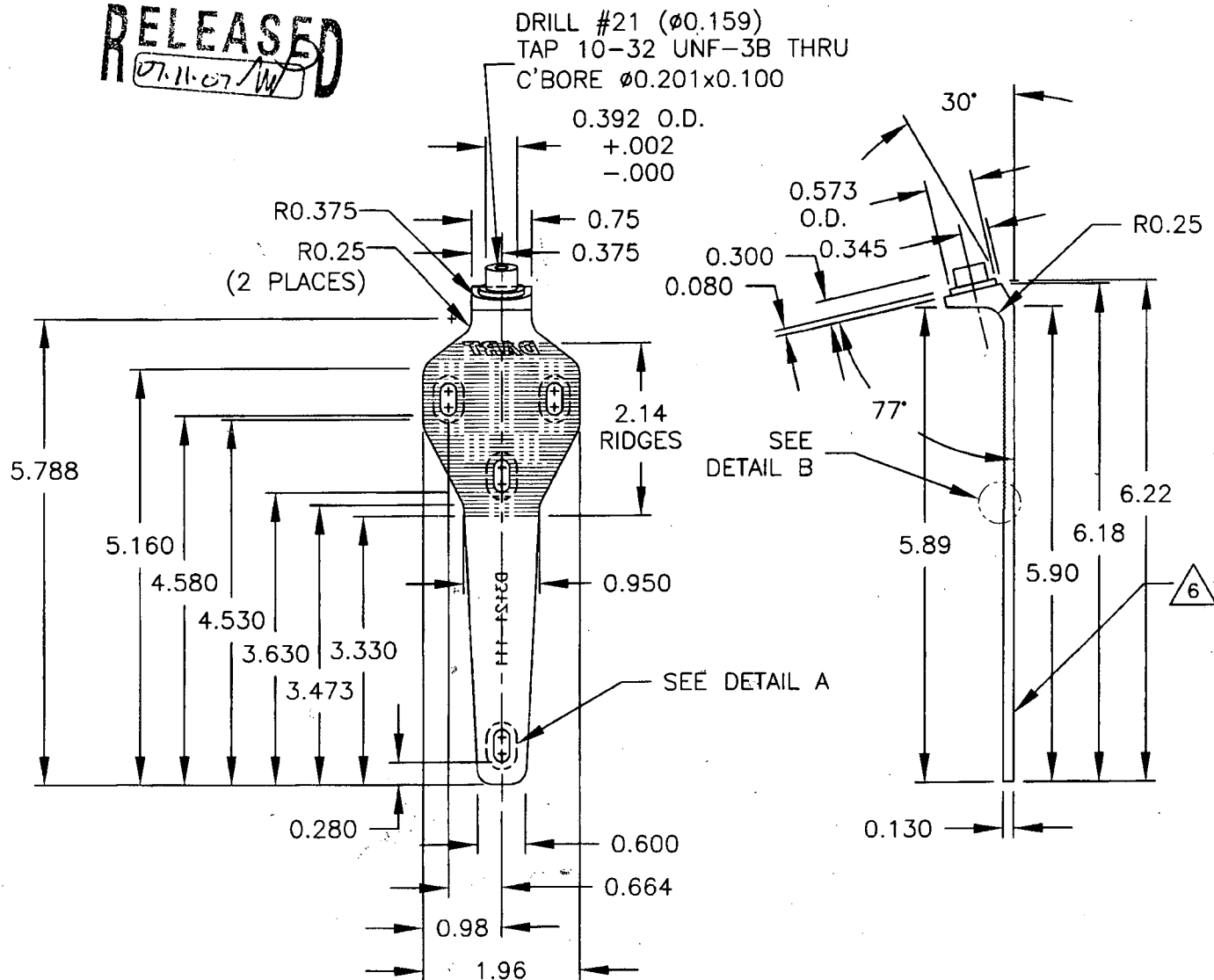
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
07.11.07



- 1) REPLACES PREMIER P/N B32-23001-11
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

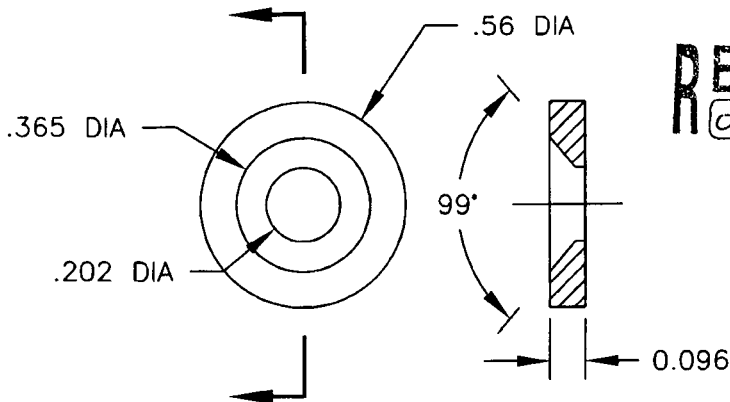
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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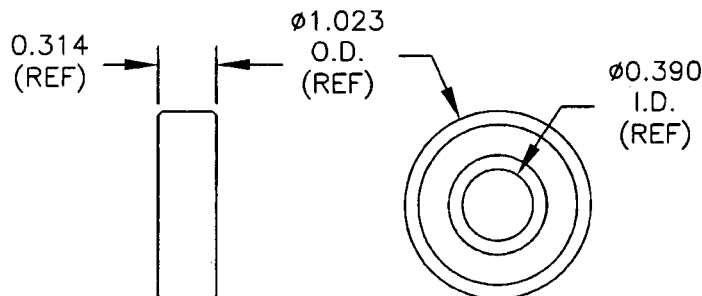
NOTE: Date & initial all entries

DART

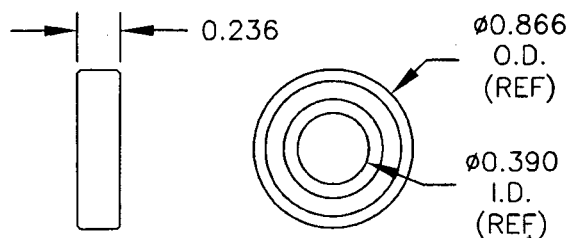
DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 10 OF 10
DATE 07.11.07	TITLE BRACKET ASSEMBLY		SCALE 1:1

**D3121-17 WASHER (SCALE 2:1)**

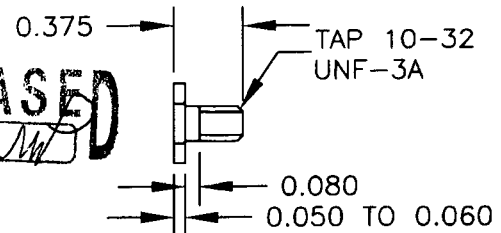
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

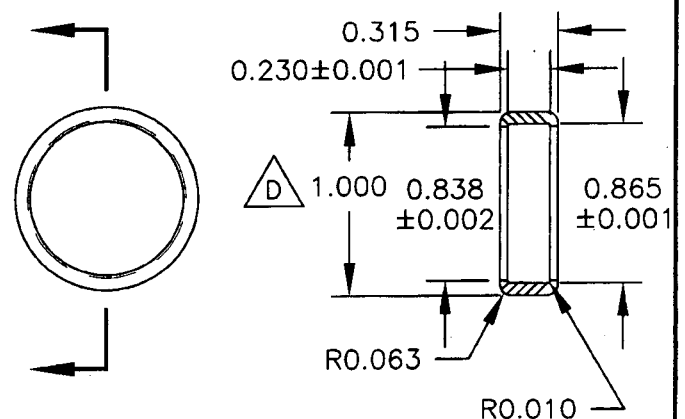
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

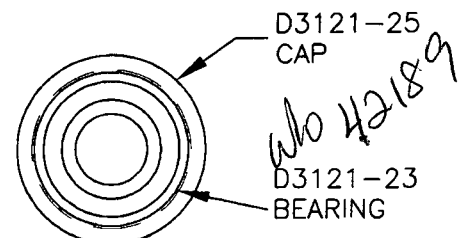
- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, $\phi 1.25$ (REF DART SPEC. M-DELIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Invoice

36 Colonnade Road N.
Ottawa, Ontario K2E 7J6
Tel: (613) 226-1579
Fax: (613) 226-1719

DATE	INVOICE NO.
11/14/2008	17343

BILL TO
Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7

SHIP TO
Main Finished Goods Location Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7

P.O. NO.	TERMS	SHIP DATE	SHIPPED VIA	JOB NO.	FOB
00007241	Net 30	11/17/2008	FedEx	812	Globus

QTY	DESCRIPTION	UNIT PRICE	AMOUNT
139	D3121141 Bracket Assembly Business Number: 102122058 <i>08/11/20</i> <i>08.11.17</i>		

WHITE = Original
BLUE = C of C
YELLOW = Packing Slip

Carrying Charge - 2% per Month -24% per Annum
on Overdue Accounts



Invoice

36 Colonnade Road N.
Ottawa, Ontario K2E 7J6
Tel: (613) 226-1579
Fax: (613) 226-1719

DATE	INVOICE NO.
11/14/2008	17343

BILL TO			SHIP TO		
Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7			Main Finished Goods Location Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7		
P.O. NO.	TERMS	SHIP DATE	SHIPPED VIA	JOB NO.	FOB
00007241	Net 30	11/17/2008	FedEx	812	Globus
QTY	DESCRIPTION				
139	D3121141 Bracket Assembly Business Number: 102122058 WE CERTIFY THAT ITEMS LISTED HAVE BEEN MANUFACTURED IN ACCORDANCE WITH DRAWINGS AND PURCHASE ORDER SPECIFICATIONS AC 11/20				

WHITE = Original
BLUE = C of C
YELLOW = Packing Slip

Carrying Charge - 2% per Month -24% per Annum
on Overdue Accounts